

Work Order ID 80002

80002

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Wednesday, February 08, 2012 3:36:26 PM

Item ID: D4004-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Top Strap Attach Bracket

Start Date: 2/9/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *12-02-08* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4004

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004

Ensure cut is started at correct place per dwg

Batch: _____

77193

(6x)

2-Deburr

105

0.00

105

Small Fab

Memo

0.00

Small Fab

Drill and c'sink holes as per dwg and trim part to length as required.

EP 12/02/16 (6)

EP 12/02/16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

SB 12/02/16

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

AS 12-2-17 (6)

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

W 12-02-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: SK141A 0.00***140***

Packaging

Memo

0.00

Packaging

u 12.02.17

150

QC21- Final Inspection - Work Order Release

0.00


150

QC

Memo

0.00

Quality Control

12/2/21 

u 12.02.17

Picklist Print

Wednesday, February 08, 2012 3:36:25 P

Page 1

Work Order ID: 80002

Parent Item: D4004-11

Parent Item Name: Top Strap Attach Bracket

Start Date: 2/9/2012

Required Date: 2/28/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD
562 DD verf:EC

IPP Rev:B 10.05.17 as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
40456-11-144 SEAT TRACK		Purchased	No			100	f	23.0000	0.41	2.5894737			

Location

Loc Qty

Loc Code

ST

23

77193

23

2.5894737

[Handwritten signature]
2/12/16

W/O:		WORK ORDER CHANGES					
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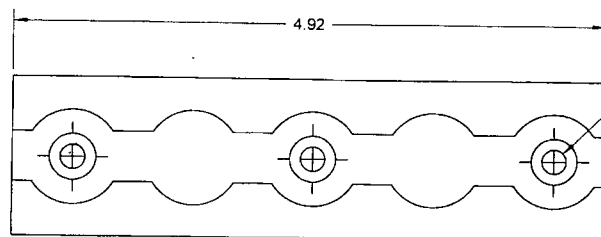
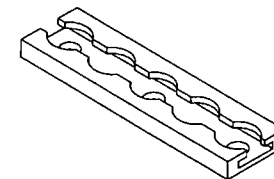
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

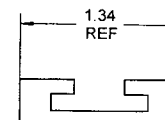
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11



DRILL $\phi 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\phi 0.385 \times 100^\circ$
3 PL



D4004-11 TOP STRAP ATTACH BRACKET

#800002
RELEASED
2010-05-05
MW

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLINE P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4004
MFG. APPR.		REV. A
APPROVED		TITLE SIDE RESTRAINT
DE APPR.		SCALE NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD
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